HiFill® PLA BF30

Techmer Polymer Modifiers - *Polylactic Acid*

General Information

Product Description	
PLAM115121	
General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Bamboo Fiber, 30% Filler by Weight
Features	• Biodegradable
Appearance	• Brown
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	50	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.05E+6	psi	ASTM D638
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Strength (Break)	10000	psi	ASTM D638
Tensile Elongation (Break)	1.6	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	8600	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	0.75	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	130	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	125	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	> 1.0E+14	ohms·cm	ASTM D257

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	130	°F
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	360 to 390	°F
Middle Temperature	370 to 400	°F
Front Temperature	380 to 410	°F
Nozzle Temperature	385 to 420	°F
Processing (Melt) Temp	370 to 415	°F
Mold Temperature	50 to 125	°F
Back Pressure [2]	50.0 to 100	psi

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Minimize to maintain fiber integrity